



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-110
Job Sheet 173293



Part No: SWA10A-110

Job Qty: 3 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A-110 Rev9 IPP Rev A 17.12.14 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		3/8/18	0.00	0.00	Start Up Machining-4		2/18/02/27
110	Mori Seiki	6 pcs		3/9/18	0.00	6.00	MORI NV5000-1		2/18/02/27
120	QC	6 pcs		3/9/18	0.00	0.00	QC2		2/18/02/27
130	QC	6 pcs		3/9/18	0.00	0.00	QC8		
140	Packaging	6 pcs		3/9/18	0.00	0.00	Packaging3 GA		GA MAR 01 2018
150	QC21-SA	6 Ea		3/9/18	0.00	0.00	QC21		2/18/03/01

Part Op 110 - 1-Machine as per folio FB FOLIO REV: DWG REV: 2-Deburr 3-
Descriptions: ***MODIFY SWA10A-100 GROOVE TO SWA10A-110 R.25" GROOVE AS PER DWG***

DAS
21
9-00
MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA10A-100P	Lower End	6 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	SWA10A-100P	6	12	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																			
Description Work Order Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, OH 44663 TEL: 1 813 832-6200 Email: sales@dartaero.com www.dartaero.com Date: 02/28/18 Container No: S046172 Part: SWA10A-110 Job No: 173293 Serial No/Batch: S046172 Revision: 9 Inspector:																									

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

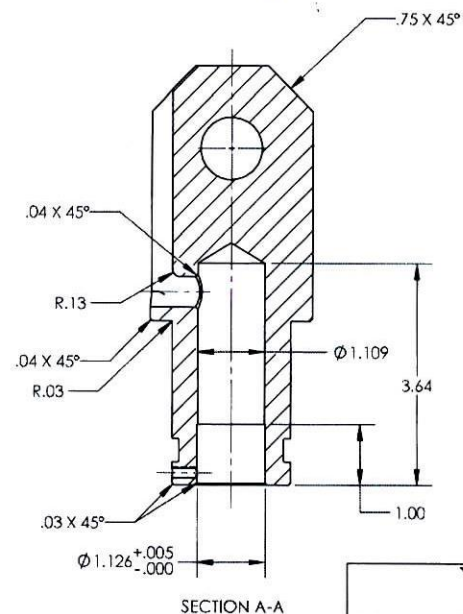
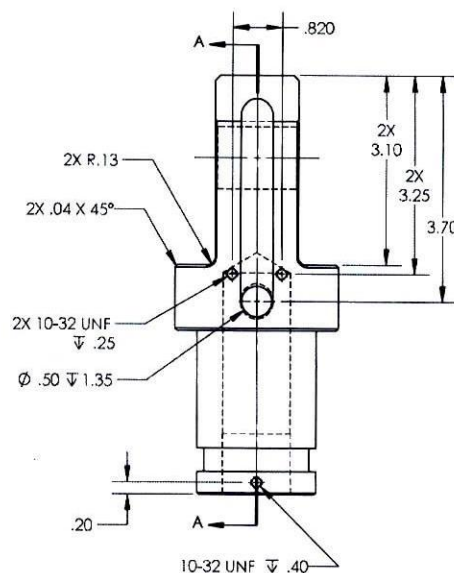
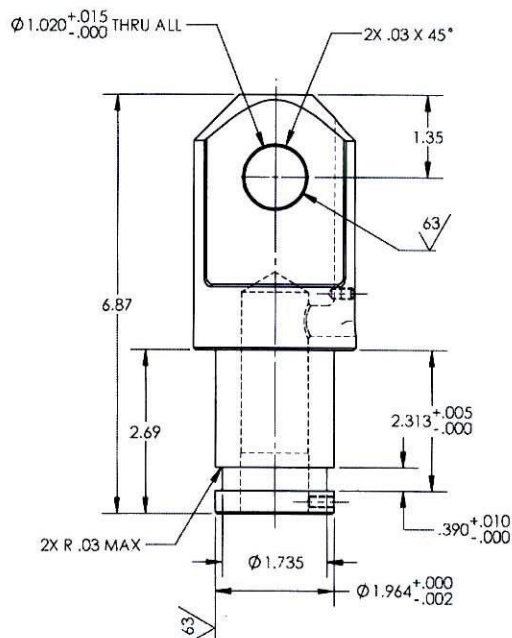
Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

Figure 10 is a technical drawing of a circular part, likely a cross-section of a cylinder. The drawing includes the following dimensions and features:

- Overall width: 1.370
- Outer diameter: $\text{Ø}2.70$
- Inner diameter (central hole): $\text{Ø}1.234$
- Distance from center to top edge: .98
- Distance from center to bottom edge: .030
- Fillet radius: $2X R.25$
- Text: "HIDDEN LINES REMOVED FOR CLARITY"

REVISIONS				
REV	ECR	DESCRIPTION	DATE	APPROVED
8		AS DRAWN BY CANAM.	11/12/2012	JAG
8A		CHD B/O TO JWA1CA-110	5/1/2014	JAG RW
9	15-0169	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATL OPTION 1/4 H' DTS. REMOVED JWA1CA-100 B/LANK FROM B/O. ADDED LUMS FROM JWA104-107 B/LANK. DEFERED UTM 366. ADDED LUMS 98 (1/2), 234. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	7/7/2015	UPL JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173293



ASSY QTY	ASSY QTY	B/D	Part #	UNIT QTY	Description	Material	B/D INFORMATION OF SPECIFICATIONS
			SWA1GA-110	1	LOWER END	SS 17-4 H1150/17-4 H1075	

		REV 9	
TITLE		LOWER END	
DWG NO.		SWA10A-110	
MATERIAL: 6017-4 H110/17-4 H1075		DRAWN BY: CANAM	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: <i>D. Ward</i>	
.XXX ± .005		FIRST FINISH	
.XX ± .01		FINISH	
.X ± .1		EPEC	
1. BREAK ALL SHARP EDGES .015 ± .45" OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:2	DATE	1/22/2002
		SHEET 1 OF 1	

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											